

Work Order ID 67632

Monday, March 28, 2011 3:48:04 PM



Page 1

Item ID: D350-607-541

Accept



Setup Start



Revision ID:

Item Name: Heli-Utility-Basket

Stop



Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-03-28

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-607-3

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-541 CHG002

Sulaloe

HJ Gar BG 11-4-8
(Label only)

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label****

ndk 11/4/11 sf

115

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Inspect label on lid

Sulaloe

④

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-607-541

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Start Date: 3/28/2011 Start Qty: 1.00

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

130

~~Pick Kit~~

0.00



Packaging

Memo

0.00

Packaging

Package as per PPPD350-607-541

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/8 JF
mf
11-04-08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 67632

Parent Item: D350-607-541

Parent Item Name: Heli-Utility-Basket

Start Date: 3/28/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP Rev:B
11.02.09 add to install label DD verf by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D350-607-511	CH1000	Manufactured	No			110	Each	0.0000	1	1			
--------------	--------	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Quick Release Basket Mounting Installation

D2690-6		Manufactured	No			110	Each	42.0000	1	1			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Lanyard Assembly

Location

Loc Qty

Loc Code

ST020

42

66029

3

66509

19

66873

20

D3912-041		Manufactured	No			110	Each	7.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Eyebolt Receiver Assembly

Location

Loc Qty

Loc Code

st507

7

65323

1

66996

6

D4030-041		Manufactured	No			110	Each	0.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Long Basket Assembly (350)

D4085-3		Manufactured	No			110	Each	3.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Placard, Instructions

Location

Loc Qty

Loc Code

ST122

3

60960

3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 67632

Parent Item: D350-607-541

Parent Item Name: Heli-Utility-Basket

Start Date: 3/28/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4086-200

Manufactured No

110 Each

10.0000



Placard, Max Load



11/4/75

→ installation
D4030-001 B67633

Location

Loc Qty

Loc Code

ST122

10

66276

10

D4151-041

Manufactured No

110 Each

0.0000



Basket Fwd Hardpoint Assembly, Lower



B67656 11/4/75

D4151-043

Manufactured No

110 Each

0.0000



Basket Fwd Hardpoint Assembly, Upper



B68042 11/4/75

D4150-041

Manufactured No

110 Each

0.0000



Attachment Arm Assembly



B67694 11/4/75

AN4-13A

Purchased No

110 Each

338.0000



Bolt



11/4/75

Location

Loc Qty

Loc Code

ST357

338

116786

38

117094

300

AN4C15

Purchased No

110 Each

11.0000



BOLT



11/4/75

Location

Loc Qty

Loc Code

ST358

11

114669

11

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 67632

Parent Item: D350-607-541

Parent Item Name: Heli-Utility-Basket

Start Date: 3/28/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

110

Each

39.0000

Nut

Location

Loc Qty

Loc Code

ST324

39

116741

39

110

Each

10.0000

MS17984-C413

Purchased

No

PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST315

10

116823

10

110

Each

3,343.000

MS21042L4

Purchased

No

Nut

Location

Loc Qty

Loc Code

ST300

3343

116188

1343

116823

2000

110

Each

524.0000

MS24665-151

Purchased

No

Cotter Pin

Location

Loc Qty

Loc Code

ST309

524

17566

524

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 67632

Parent Item: D350-607-541

Parent Item Name: Heli-Utility-Basket

Start Date: 3/28/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H4L

Purchased

No

110

Each

53.0000



WASHER

12 12
M114263

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

13

116900

13

NAS1149F0432P

Purchased

No

110

Each

18.0000



Washer

12 12
M117291 11/4/75

Location

Loc Qty

Loc Code

ST275

18

116737

18

NAS1149C0463R

Purchased

No

110

Each

179.0000



Washer

3 3
11/4/75

Location

Loc Qty

Loc Code

FP-B

132

115358

132

ST297

47

116900

47

3

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-607-541 (Standard Basket)	80.7 lb 36.6 kg	± 49.1 in ± 1.25 m	± 3962 in-lb ± 45.8 m-kG	135 in 3.43 m	10895 in-lb 125.5 m-kG
D350-607-543 (Lightweight Basket)	65.7 lb 29.8 kg	± 49.1 in ± 1.25 m	± 3226 in-lb ± 37.3 m-kG	135 in 3.43 m	8870 in-lb 102.2 m-kG
D350-607-545 (Standard Basket)	58.7 lb 26.2 kg	± 49.1 in ± 1.25 m	± 2882 in-lb ± 32.8 m-kG	135 in 3.43 m	7925 in-lb 89.9 m-kG
D350-607-547 (Lightweight Basket)	47.7 lb 21.6 kg	± 49.1 in ± 1.25 m	± 2342 in-lb ± 27.0 m-kG	135 in 3.43 m	6440 in-lb 74.1 m-kG
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kG	135 in 3.43 m	972 in-lb 11.3 m-kG

5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				4	4	D3910-3	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1	1	1	1		1	D4085-3	PLACARD-INSTRUCTIONS
1					1	D4086-200	PLACARD, MAX LOAD
	1				1	D4086-215	PLACARD, MAX LOAD
		1			1	D4086-220	PLACARD, MAX LOAD
			1		1	D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
6	6	6	6		6	AN4-13A	BOLT
				16	16	AN4-14A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	16	22	MS21042L4	NUT (OR MS21042-4)
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	32	44	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER

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